

Work Order ID 109432

109432

Page 1

November-21-13 2:23:44 PM

Item ID: D3685-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bipod Mount Ass'Y
 Start Date: 11/21/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 11/21/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12-11-25 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3685	E

100 Pick Kit 0.00

100

Packaging Memo 0.00

Packaging

① SAN 14/02/05

110 Small Fab 0.00

110

Small Fab Memo 0.00

Small Fab

1-Align the pilot holes in mating parts. Drill out each hole using pilot drill and ream each hole using a step reamer. Clean and deburr all holes prior to assembly as per dwg. (SEE NOTE 8)

AFTER FINISH DRILLIN AND REAMING PARTS MUST STAY TOGETHER. DO NOT MIXE THEM UP

2-Assemble D3684-049/-047 & D3687-3 Using Hysol EA934NA or MAGNOBOND 6398 adhesive between mating surfaces as per Dwg D3684

① SAD 14/02/05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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14-01-05

DQA: _____ Date: _____



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Picklist Print

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Page 1

Work Order ID: 109432
 Parent Item: D3685-041
 Parent Item Name: Bipod Mount Ass'Y

Start Date: 11/21/13
 Start Qty: 1.00

Required Date: 11/21/13
 Required Qty: 1.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:LL
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC
 03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD
 IPP REV:C AS PER REV D 10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3684-047 Fwd Leg Ass'Y		Manufactured	No				Each	3.0000				SAO 14/02/03	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				st200		3							
				102870		1							
				97521		2							
D3684-049 Aft Leg Ass'Y		Manufactured	No				Each	3.0000				SAO 1 14/02/03	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				st200		3							
				102871		1							
				97108		1							
				97522		1							
D3687-3 Mount		Manufactured	No				Each	13.0000				SAO 1 14/02/03	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST224		13							
				93757		13							
HL32PB8-14 Pin		Purchased	No				Each	124.0000				SAO 4 14/02/03	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST284		124							
				123916		4							
				125436		120							

DQA: _____ Date: _____



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Picklist Print

November-21-13 2:23:44 PM

Page 2

Work Order ID: 109432

Parent Item: D3685-041

Parent Item Name: Bipod Mount Ass'Y

Start Date: 11/21/13

Required Date: 11/21/13

Start Qty: 1.00

Required Qty: 1.00

HL86-8

Purchased

No

Each

160.0000

Collar

SAD⁴ 11/02/03

4

Location

Loc Qty

Loc Code

ST284

160

124724

7

125436

53

m126267

100

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

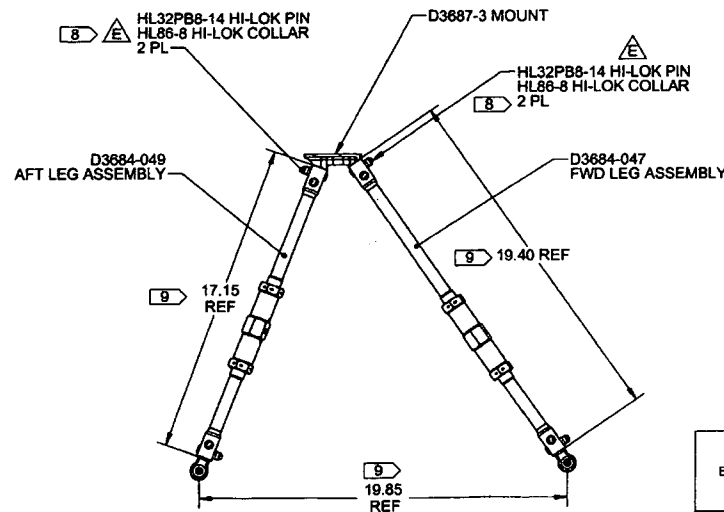
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3685-041	BIPOD MOUNT ASSEMBLY
2	1	D3687-3	MOUNT
3	1	D3684-047	FWD LEG ASSEMBLY
4	1	D3684-049	AFT LEG ASSEMBLY
5	4	HL32PB8-14	HI-LOK PIN
7	4	HL86-8	HI-LOK COLLAR



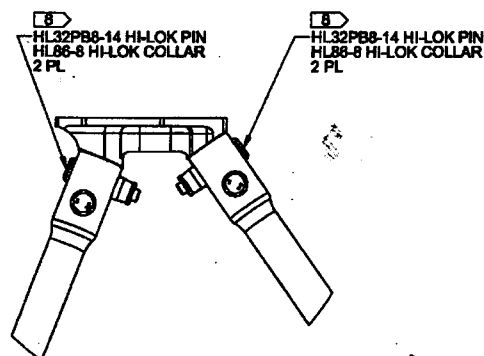
D3685-041 BIPOD MOUNT ASSEMBLY

NOTES:

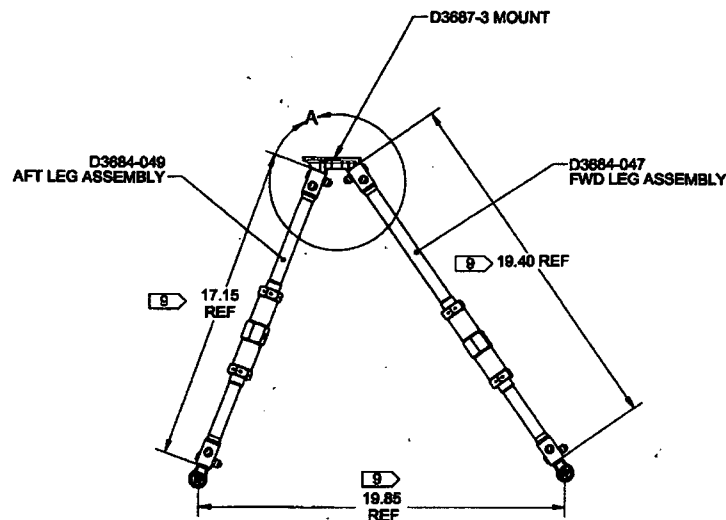
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3685-041 PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 6.68 lbs
- 8) ALIGN THE PILOT HOLES IN MATING PARTS. DRILL OUT EACH HOLE USING A P/N 13-420 PILOTTED DRILL (0.2314 DIA/0.2158 PILOT). REAM EACH HOLE USING A P/N 44-300 STEP REAMER (0.247 DIA/0.2314 PILOT). CLEAN AND DEBURR ALL HOLES PRIOR TO ASSEMBLY. ASSEMBLE D3684-047-049 WITH D3687-3 USING HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE BETWEEN MATING SURFACES.
- 9) DIMENSIONS SHOWN ARE WHEN D3688-1/3 & D3691-041 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES

E	REMOVE AN3C-12A BOLT, D3692-1 SPACER AND MS21043-3 NUT, REPLACE WITH HL32PB8-14 HI-LOK PIN, HL86-8 HI-LOK COLLAR (ZN C3-1, ZN C5-1); RE-FORMAT NOTES SECTION AS PER QSI 043. CHANGE ASSEMBLY ADHESIVES, NOTES (ZN A8-1) CHANGE BOM TABLE TO REFLECT NEW ASSEMBLY STRUCTURE, (ZN D6-1) REF NGR 12-2074	DB	12.12.05
D	17.15 WAS 17.27 (ZN B6-1); 19.40 WAS 19.52 (ZN B4-1); 19.85 WAS 20.24 (ZN B5-1)	RF	10.03.03
C	NOW ASSEMBLED USING SEALANT (ZN A8-1, C4-1)	RF	08.12.15
B	19.52 WAS 19.95 (ZN B4-1); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	MB	DRAWING NO.	REV. E
MFG. APPR.	JLM	D3685	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BIPOD MOUNT ASSEMBLY	NTS.
DATE	12.12.05	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR DISSEMINATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

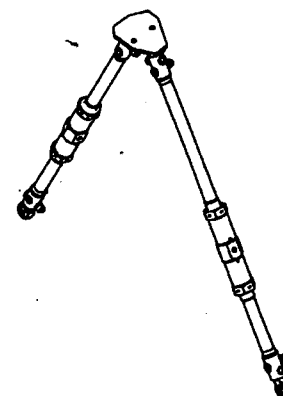
ITEM	QTY	PART NUMBER	DESCRIPTION
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2	1	D3684-047	FWD LEG ASSEMBLY
3	1	D3684-049	AFT LEG ASSEMBLY
4	4	HL32PB8-14	HI-LOK PIN
5	4	HL86-8	HI-LOK COLLAR



DETAIL A
SCALE 3X



D3685-041 BIPOD MOUNT ASSEMBLY



RELEASED
2013-12-05

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3685-041 PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 6.68 lbs
- 8) ALIGN THE PILOT HOLES IN MATING PARTS. DRILL OUT EACH HOLE USING A P/N 13-420 PILOTED DRILL (0.2314 DIA/0.2158 PILOT). REAM EACH HOLE USING A P/N 44-300 STEP REAMER (0.247 DIA/0.2314 PILOT). CLEAN AND DEBURR ALL HOLES PRIOR TO ASSEMBLY. ASSEMBLE D3684-047/-049 WITH D3687-3 USING HYSOL EA834NA OR MAGNOBOND 6388 ADHESIVE BETWEEN MATING SURFACES. HI-LOK PIN ORIENTATION AS PER DETAIL 'A'.
- 9) DIMENSIONS SHOWN ARE WHEN D3688-1/-3 & D3691-041 STUDS ARE FULLY THREADED INTO D3688-1 SLEEVES

F	ADD DETAIL A, REVERSE THE INSTALLATION ORIENTATION OF HI-LOK PINS TO FACILITATE ASSEMBLY PROCEDURE, CORRECT BOM TABLE	DB	13.11.18
E	REMOVE ANG-12A BOLT, D3682-1 SPACER AND M82104S-3 NUT, REPLACE WITH HL32PB8-14 HI-LOK PIN, HL86-8 HI-LOK COLLAR (ZN C3-1, ZN C4-1); RE-FORMAT NOTES SECTION AS PER QSI 044, CHANGE ASSEMBLY ADHESIVES, NOTES (ZN A3-1), CHANGE BOM TABLE TO REFLECT NEW ASSEMBLY STRUCTURE, (ZN D6-1) REF NCR 12-2074	DB	12.12.05
F	17.15 WAS 17.27 (ZN B6-1); 19.40 WAS 19.52 (ZN B4-1); 19.85 WAS 20.24 (ZN B5-1)	RF	10.03.03
C	NOW ASSEMBLED USING SEALANT (ZN A3-1, C4-1)	RF	08.12.15
B	19.52 WAS 19.85 (ZN B4-1); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A-U	DRAWING NO.	REV. F
MFG. APPR.	MS	D3685	SHEET 1 OF 1
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	BIPOD MOUNT ASSEMBLY	NTS
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